

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029752**Date Inspected:** 21-Jun-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Bikepath piping; OBG deck; OBG Barrier Ra**Summary of Items Observed:**

At the start of shift, this Quality Assurance Inspector (QAI) traveled to the project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) personnel. The inspection was performed on the various fillet welds of the East and West Orthotropic Box Girders (OBG's).

The welding was performed utilizing Shielded Metal Arc Welding (SMAW) process as per the Welding Procedure Specifications (WPS's).

This QAI witnessed AB/F Quality Control (QC) Andrew Keech perform an Ultrasonic Testing (UT) inspection of Westbound OBG deck repair area at location PP16(+1230)/W5(-3710). No indications were noted at this time.

Welding was witnessed by this QAI being performed of 2-1/2" diameter water piping full penetration butt splice by F.W. Spencer welder Tim Esquivel #8348 utilizing E6010 electrodes for the root pass and E7018 electrodes for the fill and cap passes as per the approved WPS #1. The location of the weld performed was at Bikepath PP109. The AB/F Quality Control (QC) Inspector Fred Michels was present, monitoring the WPS parameters of the welding in progress.

The welding of the Eastbound Barrier Rail skirt strip at south-side face (adjacent OBG deck surface) per AB/F RFI #3356 at location from PP127.5-to-PP128.3 is in progress, but not completed. The welding is being performed by #3040 Eric Sparks of AB/F utilizing E7018 electrodes as per the approved WPS #F1200A. AB/F QC William Sherwood was present, monitoring the WPS parameters of the welding in progress.

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Summary of Conversations:

There were general conversations with the contractor's Quality Control personnel at the start of the shift regarding the location of welding and inspection personnel scheduled for this shift.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Morris, Monty
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Quality Assurance Inspector

Reviewed By:	Reyes, Danny
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QA Reviewer
